



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2806-1
Job Sheet 169880



Part No: D2806-1

Job Qty: 10 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Transport Canada (CTRAN06)

Accounts Payable, Unit AFFA, 330 Sparks Street Ottawa, ON, K1V 0N5 Canada ph:(613) 998-3145

Note: DWG REV A IPP: B 05.03.11 Part now turned KJ/JLM IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-1		<i>100 18/01/20</i>
100	Doosan	10 pcs	1/11/18	1/11/18	0.00	1.04	Doosan		<i>100 18/01/20</i>
120	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC8		<i>100 18/01/21</i>
130	HandFinish	10 pcs	1/12/18	1/12/18	0.00	0.14	HandFinish1		<i>2018/01/22 25C</i>
140	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC7-1		<i>33</i>
150	Packaging	10 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1	<i>504</i>	<i>AT 18/01/22</i>
160	QC21-SA	10 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- Turn as per Folio FA105 Rev: _____ & Dwg D2806 Rev: _____ 2-Deburr per dwg D2806

DAS
21
9-00

JAN 23 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6H1.000	1	10	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.000inches ± 0.010	<i>1.003</i> 1.010 0.990		
2	Bushing	1.155inches ± 0.010	<i>1.145</i> 1.165 1.145		
3	Bushing	0.250inches ± 0.010	<i>0.245</i> 0.260 0.240		
4	Bushing	0.063inches ± 0.010	<i>0.060</i> 0.073 0.053		
5	Bushing	45.000Degrees ± 0.000	<i>45°</i> 45.000 45.000		
6	Bushing	0.080inches ± 0.010	<i>0.072</i> 0.090 0.070		
7	Bushing	45.000Degrees ± 0.000	<i>45°</i> 45.000 45.000		
8	Bushing	0.495inches	<i>0.4925</i> 0.495		

			+ 0.000		0.490
			- 0.005		
9	Bushing	0.750inches	+ 0.000	0.747	0.750
			- 0.005		0.745
10	Bushing	0.257inches	+ 0.005	0.262	0.262
			- 0.000		0.257
11	Bushing	0.094inches	± 0.010	0.092	0.104
					0.084

Plex 1/3/18 8:13 AM dart.poulin.mario

DART
AEROSPACE
S034016

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Bushing

PART NO: D2806 — 1

Original Serial #: S034016

Revision:

Operation: Start up Operation 01/20/18

Change No:

Job No: 169880

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2806-1 Revision: Bushing														
160	QC21-SA	S034016	169880	10 Ea	0	S034016	ST011	Bin	Stock	1/20/2018	Issue Container			
Operation Totals:		1		10	0									
Part Totals:		1		10	0									
Part Number: M6061T6H1.000 Revision: 6061-T6 Hexbar 1.00														
100	Receive Ft	S034015	169880	1 ft	0	m136687	Start Up Machining-1		Stock	1/20/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Totals:		2		11	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					